

Work Order ID 55516

January 19, 2010 2:29:45 PM

Page 1

Item ID: D350-748-201

Accept

Setup Start

Revision ID:

Stop

Item Name: Crosstube Installation, High Aft

Start Date: 1/20/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 2/9/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: mf Date: 10-1-19 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D350-748-241	Rev E
--------------	-------

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD350-748-201

CHG001

Sid 10/24

H. Corcl 10/08/23

110

0.00



BENDING MACHINE - CROSSTUBES

CNC Bend 2

Memo

0.00

CNC Alpha 160 Bender

Bend tube as per Dwg D350-748-241 using CNC bender program D350A and Folio FT _____

(IX) Q. MB 10-06-09

120

0.00



QC15- Crosstube Dimensional Check

QC

Memo

0.00

Quality Control

Sid 10/24

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Required Date: 2/9/2010 Req'd Qty: 1.00



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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Crosstubes	Crosstubes	0.00							
Crosstubes	Memo	0.00							
Crosstubes	1-Drill Tube as per Dwg D350-748-241 Using DT8876 Drill Jigs, Set-up drill table as per QSI 010								
	2-Deburr								
	3-Engrave Part # and Batch # as per Dwg D350-748-241								
	4-Remove all marks from tube within limits of D350-748-241								
	5- Apply a light coat of LPS3 on the interior of tube Batch: <u>108856</u>								
140 QC	QC6- Inspect dimensions to drawing	0.00							
Quality Control	Memo	0.00							

ALW 10-06-10

8/10/10

10

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Item ID: D350-748-201

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Required Date: 2/9/2010 Req'd Qty: 1.00



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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	Outsource process-Cadplate per QSI017 4.1.9.1	0.00							
Outsource3	Memo	0.00							
Outsource process - Cad plate	Issue P/O: <u>12062</u> Stress relief at 375° for 5 hours Magnetic Particle Inspect per ASTM E1444 Cadium Plate per AMS-QQ-P-416B, Class 1, Type 2 Embrittle relief at 375° for 8 hours, Chromate Treat Possibe Supplier: Southwest United Industries Ensure Certificate of Conformity is attached								
160 	Receive & Inspect for Damage & Mat'l Certs	0.00							
Packaging	Memo	0.00							
Packaging	Ensure certificate of conformity is attached								
170 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

CL 10/06/10 ①

10/8/10 SD

④

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-748-201 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: [Signature] Date: 10/08/18
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>55516</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.08.18	150	DAMAGE TO CAD PLATE DUE TO TRANSPORT ACCIDENT REF. NCR 10-308	<u>CP</u> 10.08.18 QS1042	Touch up CAD PLATE PER Q 10A-D350-748 CHAPTER 5	see next page	<u>S</u> 10/08/18	<u>CP</u> 10.08.18 per QS1042	<u>[Signature]</u> 10/08/18

NOTE: Date & initial all entries

**CERTIFICATE OF
CONFORMANCE**

**CADORATH PLATING CO. LTD.
2150 LOGAN AVENUE
WINNIPEG, MANITOBA R2J-0J1**

DATE: Jul-05-2010

CONSIGNED TO: Dart Aerospace Ltd.
1270 Aberdeen St.
Hawksbury, ON K6A 1K7

W/O #: 96457
INVOICE #: 50229

**CONTRACT OR
PURCHASE ORDER #**

12062

DESCRIPTION: SKID

QTY

1

P/N # D350-748-201

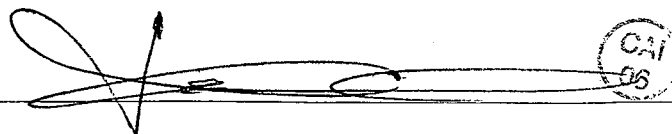
S/N # **B55516**

**STRESS RELIEF HEAT CHART #10-634. MPI IAW ASTM-E-1444.
CADMIUM PLATE IAW AMS-QQ-P-416B TYPE 2 YELLOW CLASS 1.
BAKE HEAT CHART # 10-686.**


*8/10/06/19. tubes were damaged during
transport. See next Page.*

**CERTIFICATE: I certify that the items indicated here on have
been inspected and tested and conform to all specifications
and requirements detailed on the contract or purchase order.**

Approved Inspector:





1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form tracking No. HTV-2636 Page 1 of 1	
4. Approved organization name and address HELITRADES INC. 18 Terry Fox Drive, Vankleek Hill, Ontario, K0B 1R0, Canada					5. Work order/contract/invoice H-16610	
6. Item	7. Description	8. Part No.	9. Qty	10. Serial/Batch No.	11. Status/work	
1	CROSSTUBE	D350-748-201	5	55513 55516 55515 55514 59173	REPAIRED <i>Solo</i>	
12. Remarks BRUSH CADMIUM PLATING REPAIR CARRIED OUT I.A.W. THE DART AEROSPACE ICA-D350-748 PAGE 9 OF 19 REV.1 DOCUMENTATION FOR ALL WORK PERFORMED IS AVAILABLE ON FILE UNDER HELITRADES W/O SPECIFIED IN BLOCK # 5.						
13a. Certifies that the items identified above were manufactured in conformity to: <input type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input checked="" type="checkbox"/> CAR 571.10 Maintenance Release. <input type="checkbox"/> Other regulations specified in block 12. Certifies that, except where otherwise specified in block 12, the work identified in block 11 and described in block 12 was performed in accordance with the Canadian Aviation Regulations.			
13b. Signature		13c. Approved Organization Number		14b. Signature <i>Gerald Tom</i> 		14c. Approved Organization Number AMO 3/86
13d. Name		13e. Date (dd/mm/yyyy)		14d. Name GERALD TOM		14e. Date (dd/mm/yyyy) 17-Aug-10
<p>"This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown."</p>						

(Previously form 24-0078)

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Item Name: Crosstube Installation, High Aft

Start Date: 1/20/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 2/9/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	SprayPaint	0.00							
SprayPaint	Memo	0.00							
Spray Painting	1-Prime inside crosstube as per QSI 005 4.2 2-Paint Outside of Tube as per Dart QSI 005 4.2								
190 	QC14- Inspect Spray Paint	0.00							
QC	Memo	0.00							
Quality Control	Then, Wrap in plastic bag to protect from scratches								
200 	Crosstubes	0.00							
Crosstubes	Memo	0.00							
Crosstubes	1-Install Ground wire Insert, then insert screw and washer 2-Install Abrasion strips as per Dwg D350-748-241 & QSI 035. 3-Install supports Using Dt8876 as per Dwg D350-748-241, Torque to 60-80 IN-LBS								

BT 10-06-20

8/10/08/23

FD

BT 10-08-23

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Cust Item ID:

Required Date: 2/9/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	810108/23						
220 Packaging Packaging	Pick Kit Memo	0.00 0.00	10/18/23 sf						
230 QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00	810108/24 / mm 10-08-24						

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Stop



Item Name: Crosstube Installation, High Aft

Start Date: 1/20/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 2/9/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-748-201								
	Location: <u>100</u>								
	PPP Rev: <u>A</u>								
250	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10/8/24

sf

10/08/25

CL 10/8/25

Picklist Print

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Page 1

Work Order ID: 55516



Parent Item: D350-748-201



Parent Item Name: Crosstube Installation, High Aft

Start Date: 1/20/2010

Required Date: 2/9/2010

Comments: IPP Rev: A New Issue 06-07-05 JLM
IPP Rev: B Update qty of MS21042L5 06-09-12 KJ
IPP Rev C Combined manufacturing 08.04.02 EC verified by: DD
IPP Rev:D 08-06-24 revD as per dwg DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

D350-748-241TRN

Manufactured No

110

Each

4.0000

1.0000



Crosstube Turning Detail



B-55374 MB 10-06-07

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FG

4

47167

1

47170

1

47171

1

47172

1

ALS4-1032-225

Purchased

No

200

Each

6,686.000

1.0000



Insert



M 110768

ET 10 08 23

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

6686

107441

16

110768

6670

AN960JD10

Purchased

No

200

Each

0.0000

1.0000



Washer



M 115107

ET 10-08-23

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Work Order ID: 55516



Parent Item: D350-748-201



Parent Item Name: Crosstube Installation, High Aft

Start Date: 1/20/2010

Required Date: 2/9/2010

Comments: IPP Rev: A New Issue 06-07-05 JLM
IPP Rev: B Update qty of MS21042L5 06-09-12 KJ
IPP Rev C Combined manufacturing 08.04.02 EC verified by: DD
IPP Rev:D 08-06-24 revD as per dwg DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

D2856-400

Manufactured No

200 f

290.3921 1.2432



Abraison Strip

B 56626



RT 10-08-23

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST403

290.3920842

50593

141.312084

52563

149.08

1- cut as per dwg D2856

D3502-1

Manufactured No

200 Each

83.0000 2.0000



Support



RT 10-08-23

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5

41603

2

42968

2

47120

1

Main Warehouse

ST107

40

52903

40

Main Warehouse

ST168

38

50287

38

f2

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Start Date: 1/20/2010

Required Date: 2/9/2010

Comments: IPP Rev: A New Issue 06-07-05 JLM
 IPP Rev: B Update qty of MS21042L5 06-09-12 KJ
 IPP Rev C Combined manufacturing 08.04.02 EC verified by: DD
 IPP Rev:D 08-06-24 revD as per dwg DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

MS21920-20

Purchased No

200

Each

115.3000 2.0000



Clamp (per MIL-DTL-8783C)

m114687



10-08-23

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

115.3

103478

2

106484

12

109269

9.3

110536

10

112307

32

112624

39

112793

11

MS27039-1-10

Purchased No

200

Each

203.0000 1.0000



Screw



10-08-23

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

203

112794

89

112828

14

112940

100

X1

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Work Order ID: 55516



Parent Item: D350-748-201



Parent Item Name: Crosstube Installation, High Aft

Start Date: 1/20/2010

Required Date: 2/9/2010

Comments: IPP Rev: A New Issue 06-07-05 JLM
 IPP Rev: B Update qty of MS21042L5 06-09-12 KJ
 IPP Rev C Combined manufacturing 08.04.02 EC verified by: DD
 IPP Rev:D 08-06-24 revD as per dwg DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

AN4-41A



Purchased No

220

Each

242.0000 8.0000



10/18/23 SP

Bolt

2/8

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

242

105940

4

110363

16

110731

50

111424

50

112082

22

113359

100

8

AN4-6A



Purchased No

220

Each

1,559.000 16.0000



10/18/23 SP

Bolt

2/8

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1559

112314

159

112641

100

112720

100

112829

300

112933

300

113149

600

16

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Work Order ID: 55516



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Start Date: 1/20/2010

Required Date: 2/9/2010

Comments: IPP Rev: A New Issue 06-07-05 JLM
IPP Rev: B Update qty of MS21042L5 06-09-12 KJ
IPP Rev C Combined manufacturing 08.04.02 EC verified by: DD
IPP Rev:D 08-06-24 revD as per dwg DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

AN5-32A

Purchased No

220

Each

175.0000 4.0000



MIL 40567 10/18/23 SP

Bolt

M/S

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

175

106242

3

106519

4

110363

17

112805

1

112933

50

113121

100

AN960JD416

Purchased No

220

Each

149.0000 32.0000



MIL 50007 10/18/23 SP

Washer

M/S

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

149

112314

149

16941

0

AN960JD516

Purchased No

220

Each

0.0000 8.0000



10/18/23 SP (MIL 4742)

Washer

M/S

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Work Order ID: 55516



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Parent Item Name: Crosstube Installation, High Aft

Start Date: 1/20/2010

Required Date: 2/9/2010

Comments: IPP Rev: A New Issue 06-07-05 JLM
 IPP Rev: B Update qty of MS21042L5 06-09-12 KJ
 IPP Rev C Combined manufacturing 08.04.02 EC verified by: DD
 IPP Rev:D 08-06-24 revD as per dwg DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00



D3500-1

Manufactured No

220

Each

46.0000

4.0000

Saddle

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

46

47119

12

47350

5

52326

20

53792

9

Manufactured No

220

Each

523.0000

16.0000

D3501-1



Bushing

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

523

45402

19

45918

200

48268

204

53779

100

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Work Order ID: 55516



Parent Item: D350-748-201



Parent Item Name: Crosstube Installation, High Aft

Start Date: 1/20/2010

Required Date: 2/9/2010

Comments:

IPP Rev: A New Issue 06-07-05 JLM
 IPP Rev: B Update qty of MS21042L5 06-09-12 KJ
 IPP Rev C Combined manufacturing 08.04.02 EC verified by: DD
 IPP Rev:D 08-06-24 revD as per dwg DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

MS21042L4



Purchased

No

220

Each

3,697.000, 24.0000



11117847 10/12/235

Nut
ml/5

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3697

102552

6

104248

6

110507

184

111827

2501

113422

1000

15924

0

MS21042L5



Purchased

No

220

Each

550.0000, 4.0000



1114013 10/12/235

Nut
ml/5

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

550

110382

10

111636

1

112314

39

113523

300

113537

200

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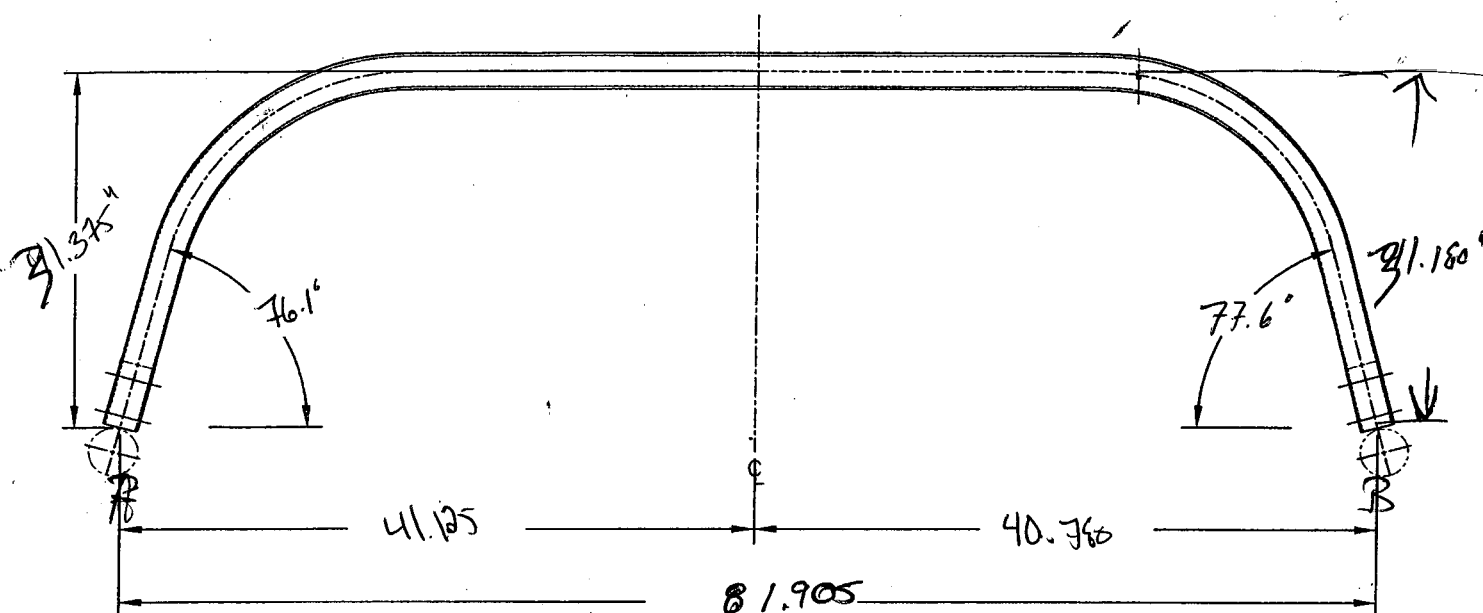
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DART AEROSPACE LTD		Work Order:	55516
Description: Crosstube High Aft (AS350/355)		Part Number:	D350-748-201
Inspection Dwg: D350-748-241	Rev: D E	Page 1 of 1	

10.01.19

Required Dimension	Min	Max
Height	31.22	31.48
1/2 Span	40.77	41.03
Angle	75	77
Total Span	81.54	82.06



Comments
twist = 0.176"
Cut 0.2" FROM HIGH CUFF. 10.06.09

QC15 Inspection	6
Date	10/06/09

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Item	Qty -241	Part Number	Description
1	X	D350-748-241	CROSSTUBE ASSEMBLY (AS 350/355 HI AFT)
2	1	D6018-125	CROSSTUBE
3	2	D3502-1	SUPPORT
4	2	D2856-400-710	ABRASION STRIP
5	1	AELS-1032-225	INSERT
6	1	NAS1149D0363J	WASHER (OR AN960JD10)
7	2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
8	1	MS27039-1-10	SCREW

55516

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6018-125
FINISHED LENGTH = 122.700±0.06
- 2) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D350-748-241" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 29.85 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR Ø0.297 HOLE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING.
- 12) INSTALL D2856-400-710 ABRASION STRIPS WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 13) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 14) TORQUE CLAMPS 60 TO 80 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
2009-10-29

E	REVISE GENERAL NOTES; UPDATE TO CURRENT STANDARDS; RELOCATED FLAG #6 PER PAR 08-046 (ZN A8-3); ADD TOLERANCES (ZN C6-3, D2-3)	RF	09.09.30
D	MAG. PARTICLE AND CAD PLATE AS MFD.	CP	06.10.31
C	ADD CAD PLATING	CP	06.08.14
B	ADD D6018-125 & PRIME AND PAINT	CP	06.06.30
A	NEW ISSUE	CP	06.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. E
CHECKED	RF	D350-748-241	SHEET 1 OF 4
MFG. APPR.	RF	TITLE	SCALE
APPROVED	RF	CROSSTUBE (AS 350/355 HI AFT)	NTS
DE APPR.	RF	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	09.09.30		

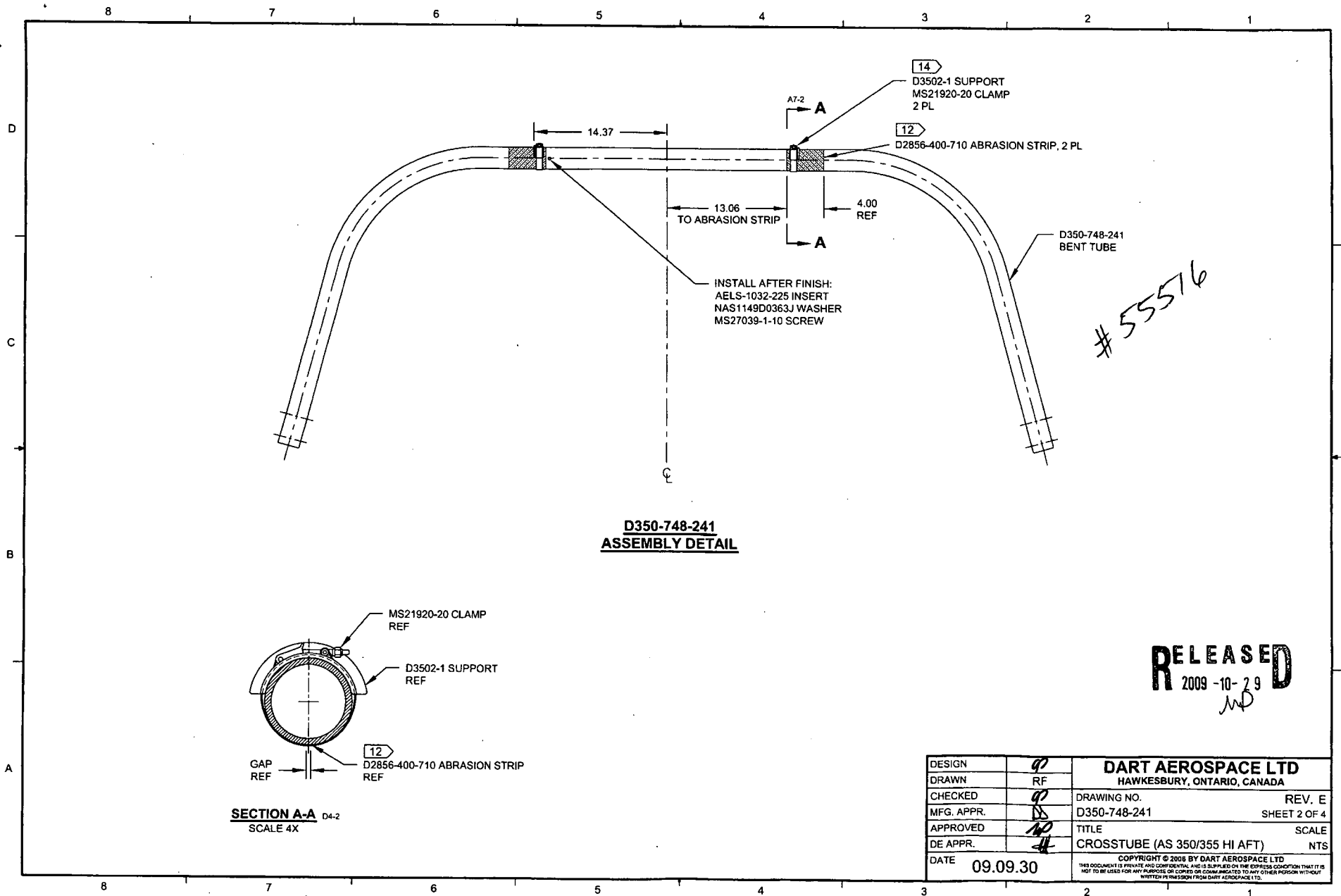
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
2009-10-29
MD

DESIGN	97	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	97	DRAWING NO.	REV. E
MFG. APPR.	18	D350-748-241	SHEET 2 OF 4
APPROVED	18	TITLE	SCALE
DE APPR.	18	CROSSTUBE (AS 350/355 HI AFT)	NTS
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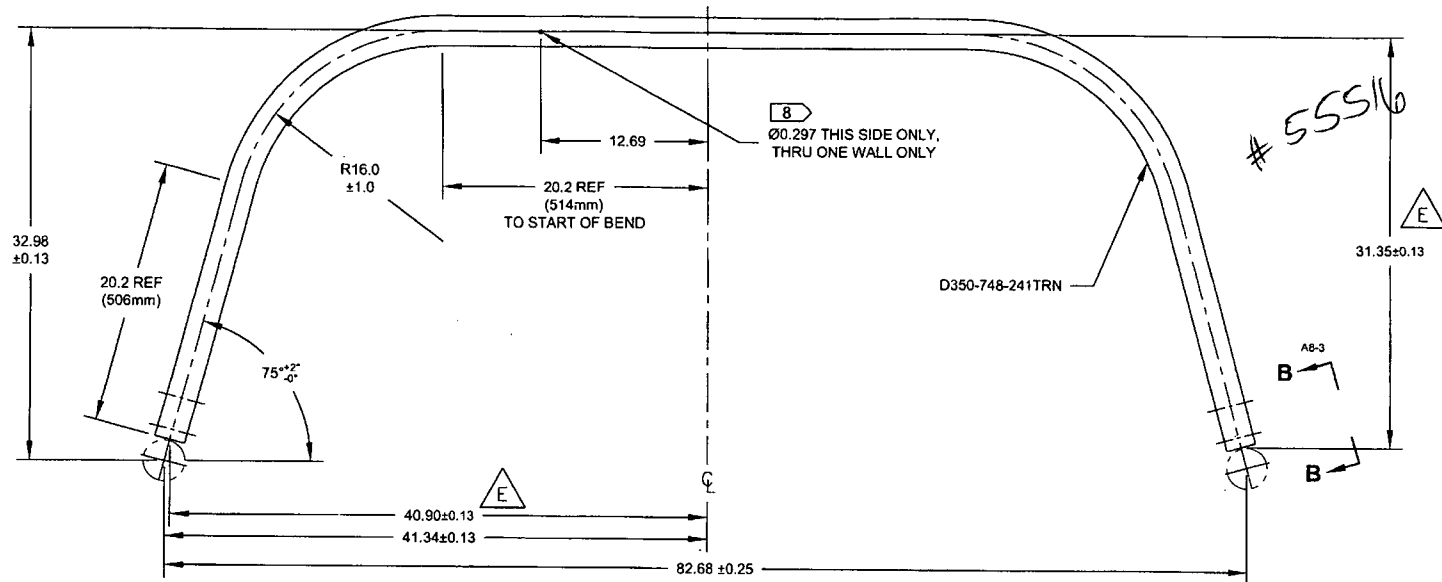
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

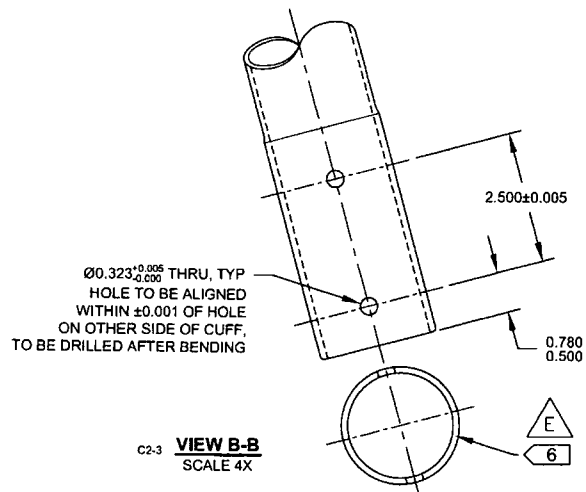
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D350-748-241
BENDING AND DRILLING DETAIL 10



RELEASED
2009-10-29
ND

DESIGN	97	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	97	DRAWING NO.	REV. E
MFG. APPR.	DS	D350-748-241	SHEET 3 OF 4
APPROVED	97	TITLE	SCALE
DE APPR.	97	CROSSTUBE (AS 350/355 HI AFT)	NTS
DATE	09.09.30	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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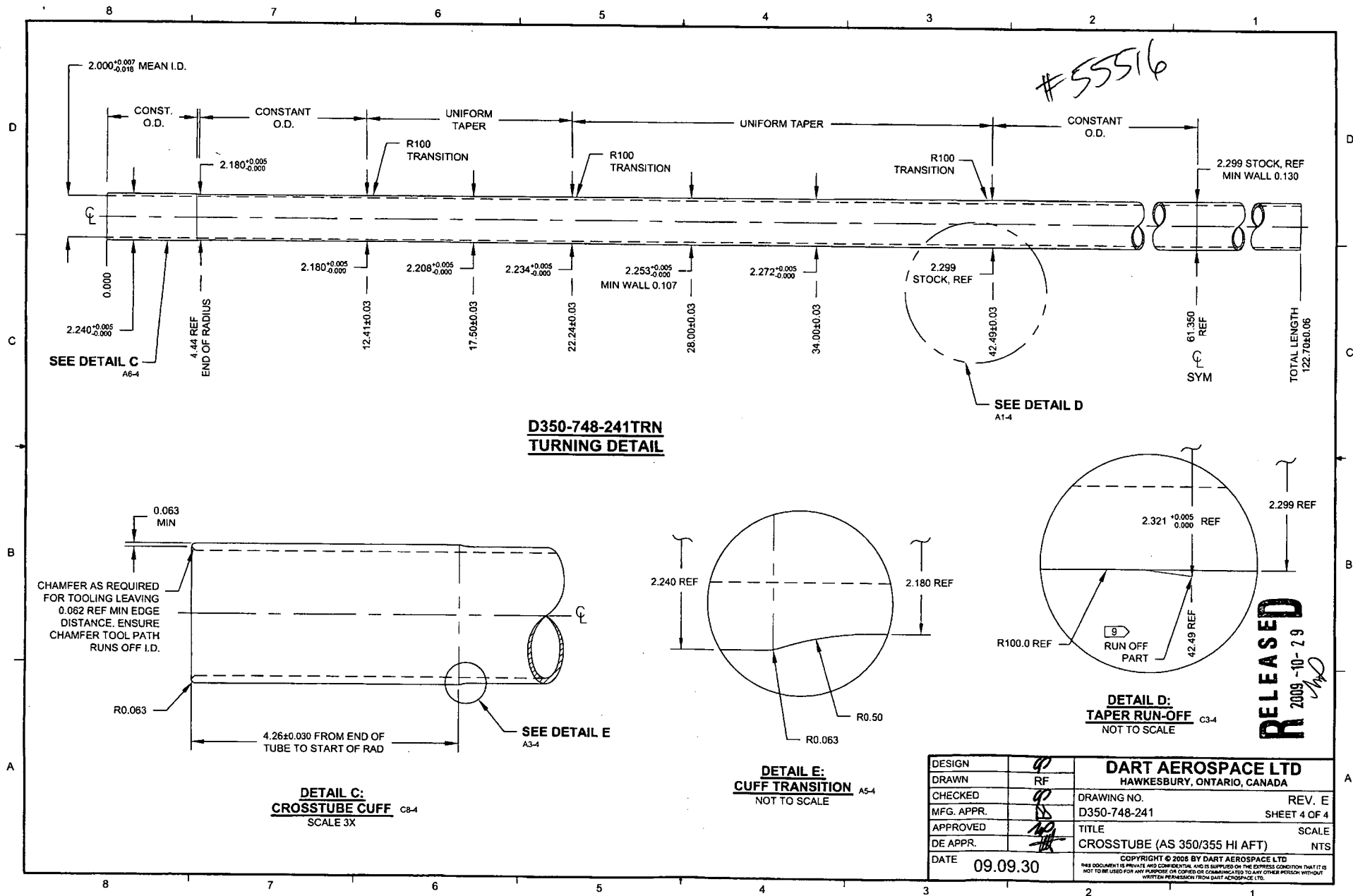
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries